

Date: Monday, 22/09/2008 2:22:32 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|----------------------------------|---|-------------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BEARING |
| Job Number | : 42200 | | |
| Estimate Number | : 10089 | | |
| P.O. Number | : | Part Number | : D312123 |
| This Issue | : 22/09/2008 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D3121 REV E |
| First Issue | : // | Project Number | : N/A |
| Previous Run | : 40397 | Drawing Revision | : E |
| Written By | : | Material | : |
| Checked & Approved By | : <u>JUL 08.9.22</u> | Due Date | : 29/09/2008 |
| Comment | : Est. A: 04.02.19 New Issue KJ/DS | Qty: | 250 |
| | Est Rev:B ECN 1060 07-11-12 DD verified by:EC | Um: | Each |

| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|-----------------------|
| 1.0 | PG | PURCHASING |
| Comment: PURCHASING Issue P/O: <u>7216</u> Bearing as per Dwg D3121 Possible Supplier: SKF P/N: 61900-2Z or KML P/N: 6900-2Z Material release note is required | | |
| 2.0 | 6900ZZ | Bearing |
| Comment: Qty.: 1.0000 Each(s)/Unit Total: 250.0000 Each(s) Bearing | | |
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached | | |
| 4.0 | QC6 | DIMENSIONAL CHECK |
| Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3121 and attached certification Dwg Rev | | |
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>67</u> | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 2:22:32 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 42200

Part Number: D312123

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 *df*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CS 08/09/29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

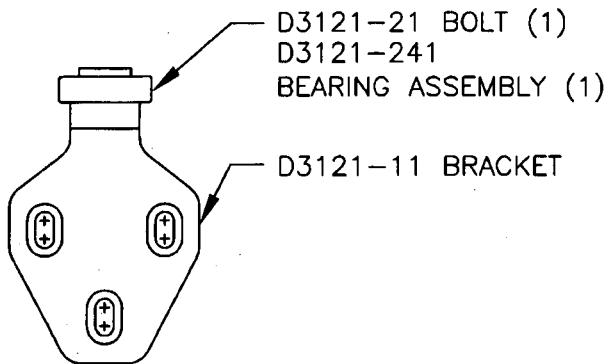
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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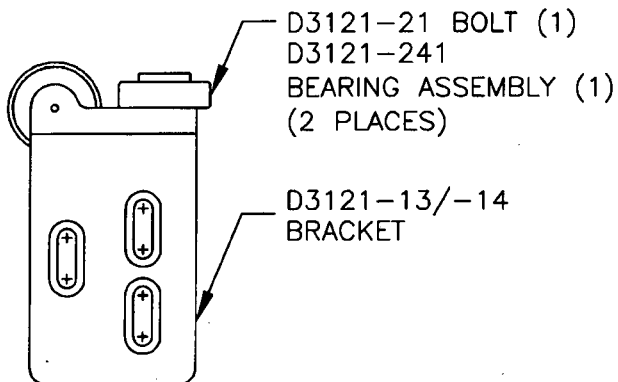
NOTE: Date & initial all entries

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07.11.07

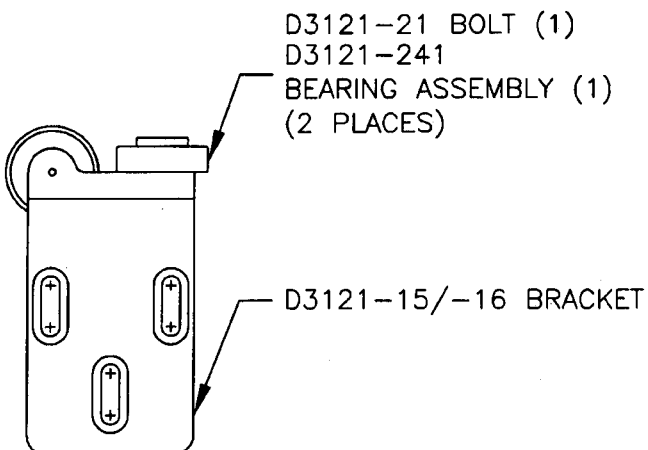
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| DESIGN # | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. E SHEET 1 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |
| A | 02.04.15 | NEW ISSUE | |
| B | 03.01.16 | ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146 | |
| C | 04.02.17 | ADD CLEARANCE; USE -241 BEARING | |
| D | 06.05.17 | D3121-25 CAP WAS 1.024, NOW 1.000 | |
| E | 07.11.07 | ADD TOLERANCE TO 0.032 (DETAIL B) | |



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

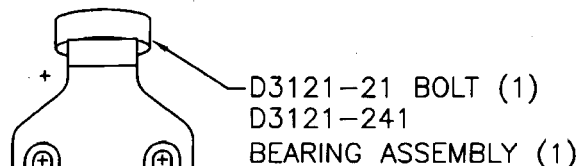
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| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |



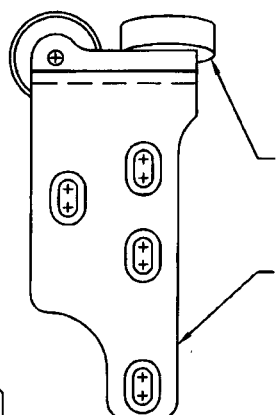
D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23001-01)

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07.11.07

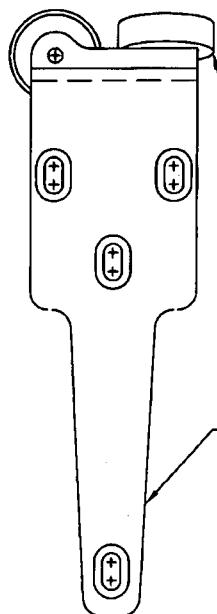


D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-05/-06)

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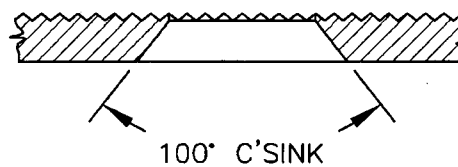
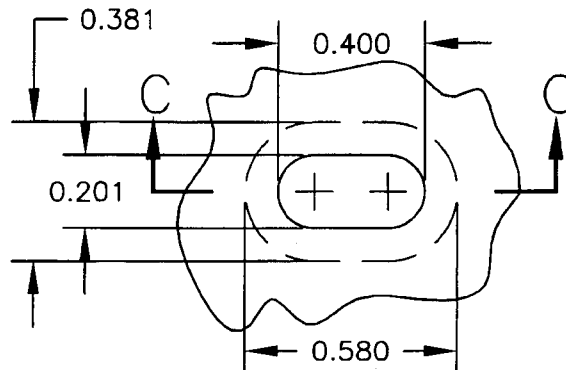
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| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:1 |

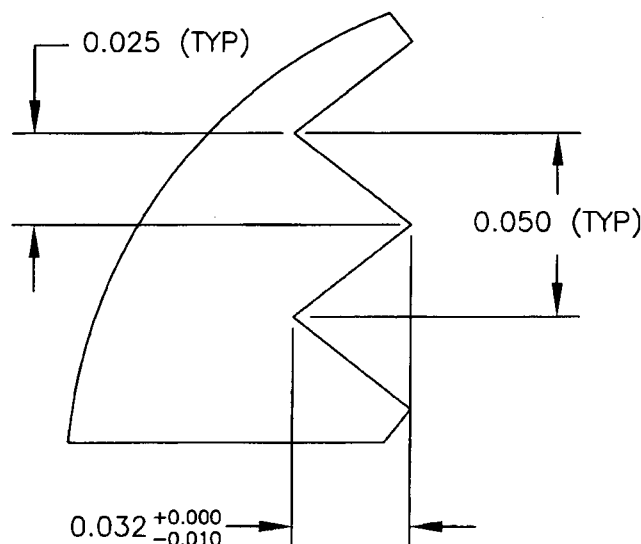
DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

RELEASED
07.11.07

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



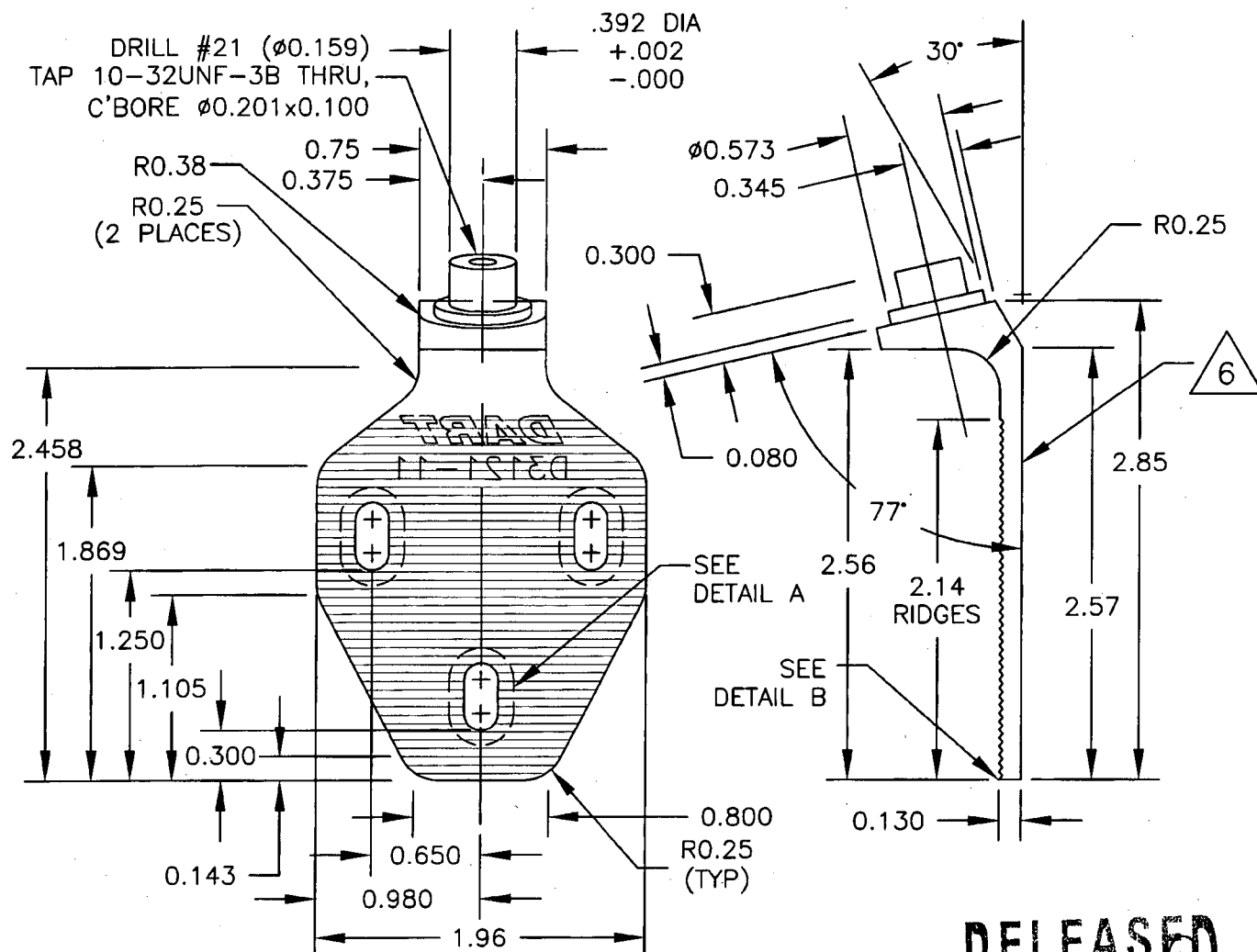
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| DATE 07.11.07 | TITLE BRACKET ASSEMBLY | | SCALE 1:1 |

**RELEASED**
07.11.07 MB**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

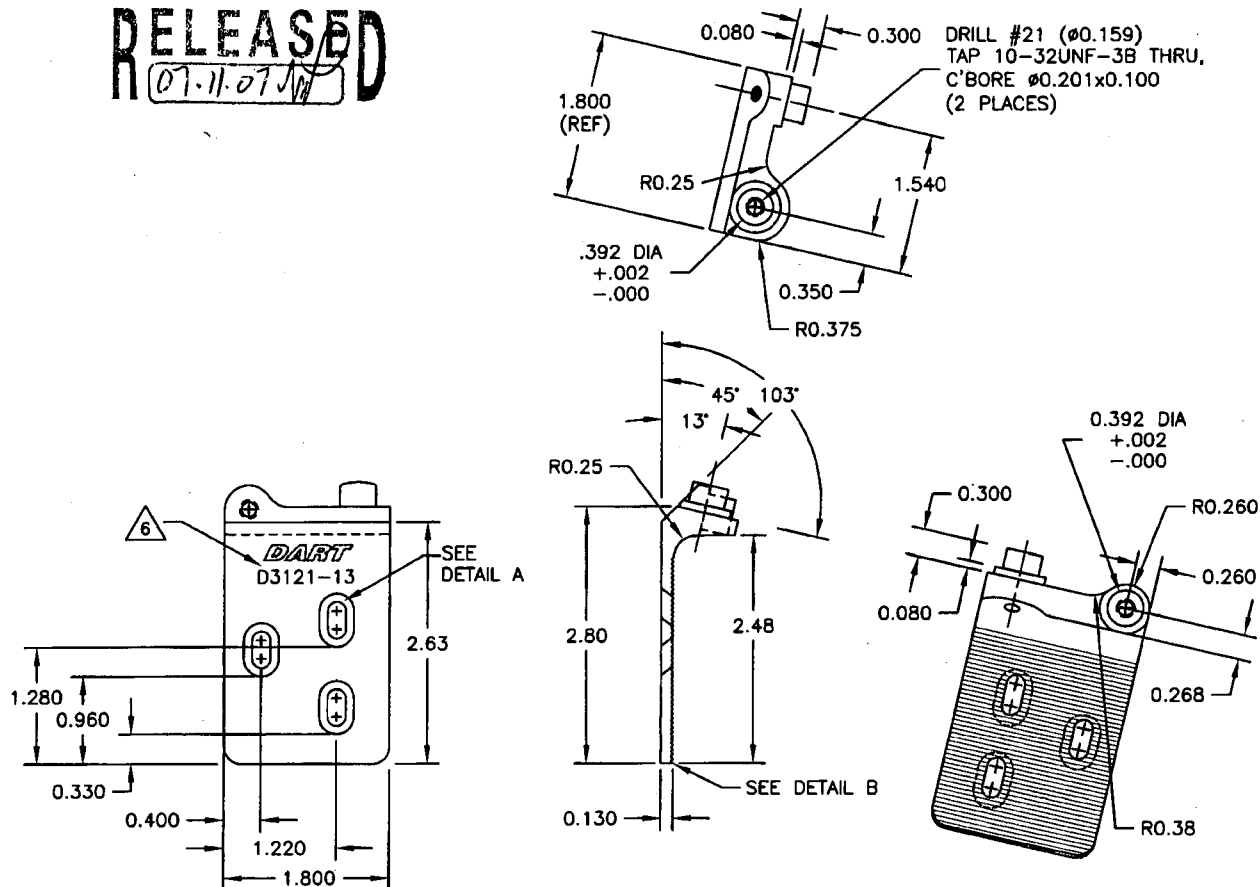
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| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |

RELEASED
07.11.07**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

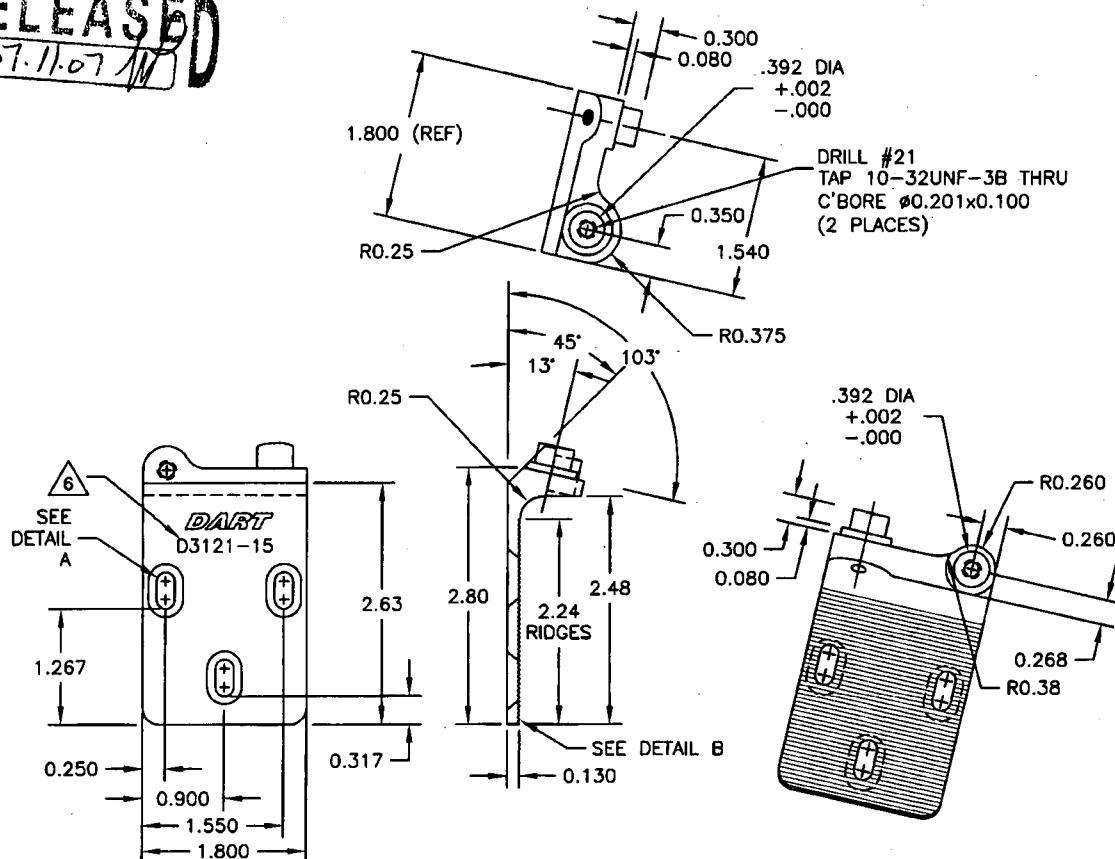
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| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |

RELEASED
07.11.07**D3121-15 BRACKET (SHOWN)****D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

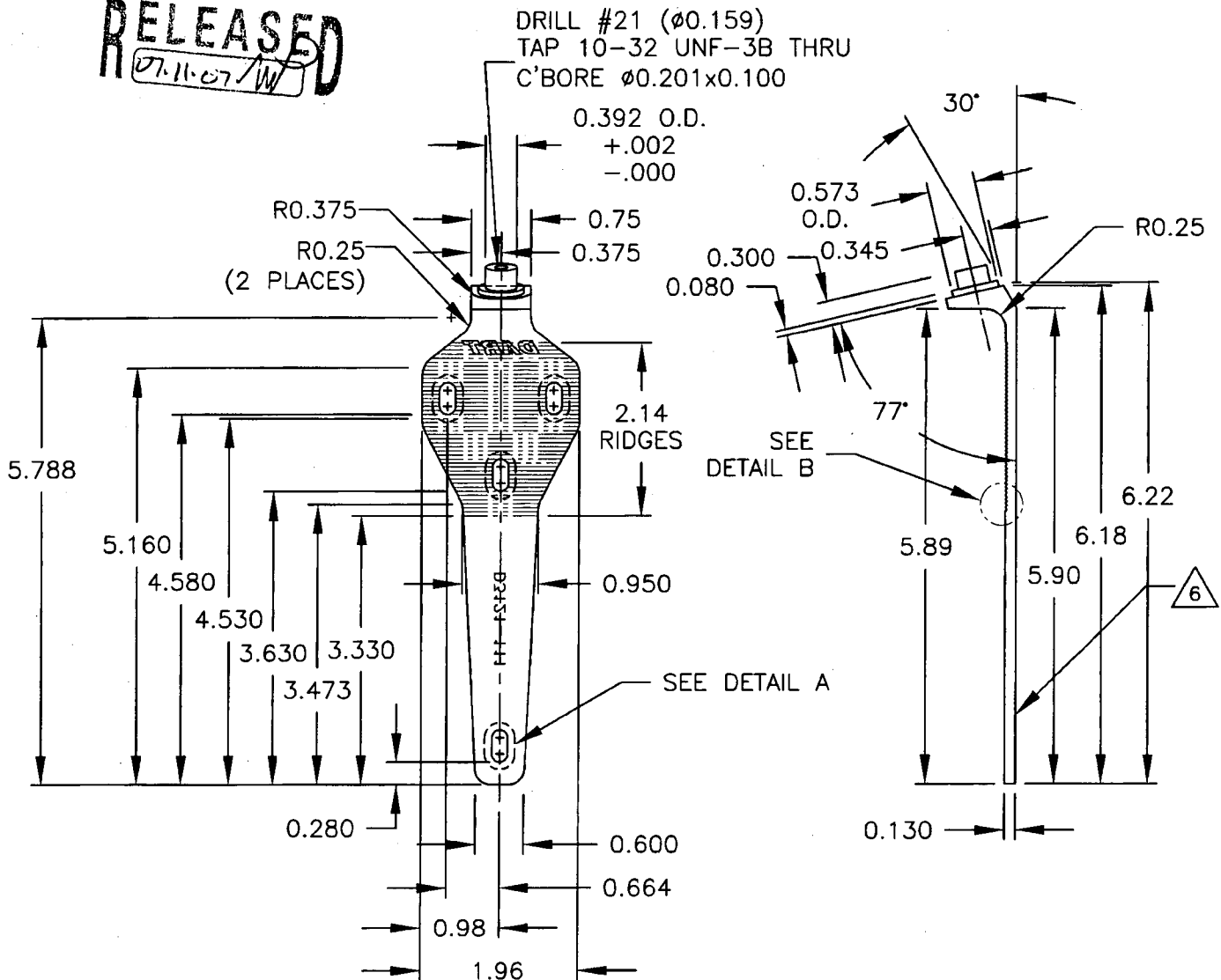
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| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |

RELEASED
07-11-07



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

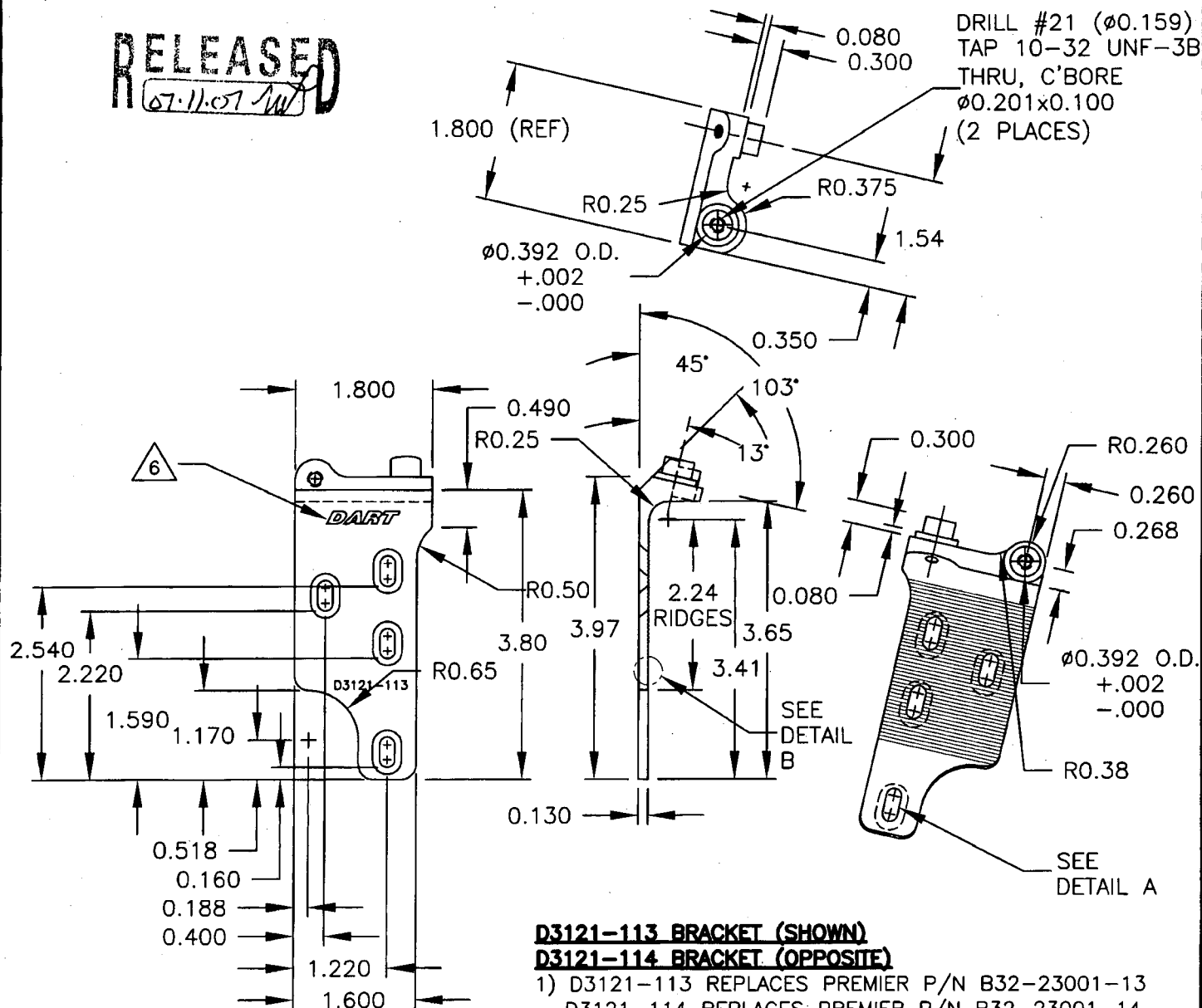
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| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |

RELEASED
07.11.07 W**D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643

(REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE STRENGTH ≥ 150 ksi
MIN YIELD TENSILE STRENGTH ≥ 100 ksi

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES

- 5) BREAK ALL SHARP EDGES 0.005 TO 0.0075

- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN

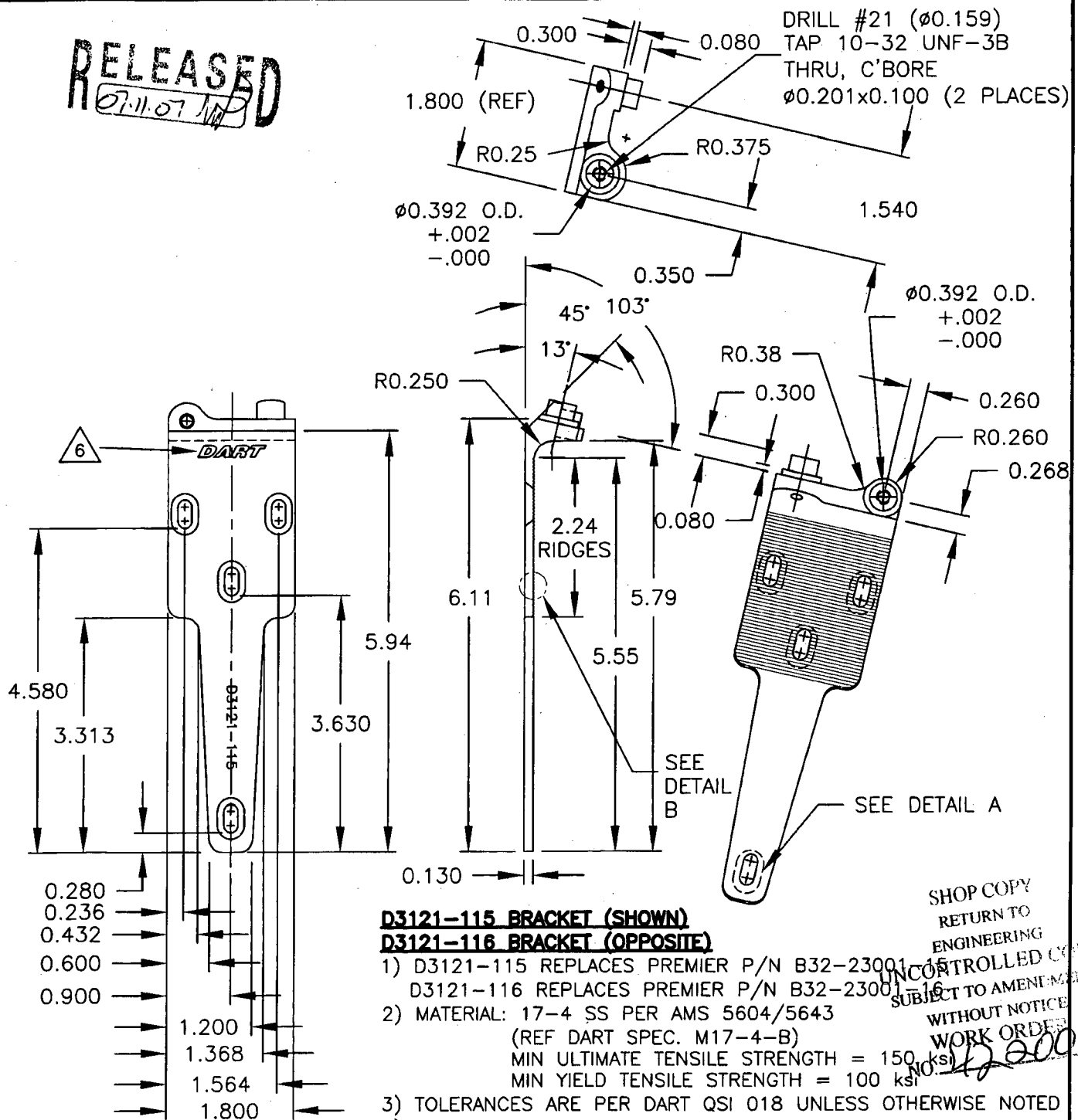
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITH

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| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |

RELEASED
07.11.07

D3121-115 BRACKET (SHOWN)
D3121-116 BRACKET (OPPOSITE)

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

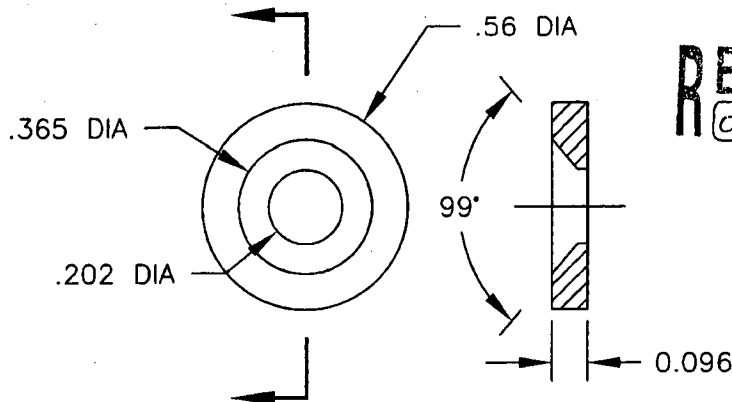
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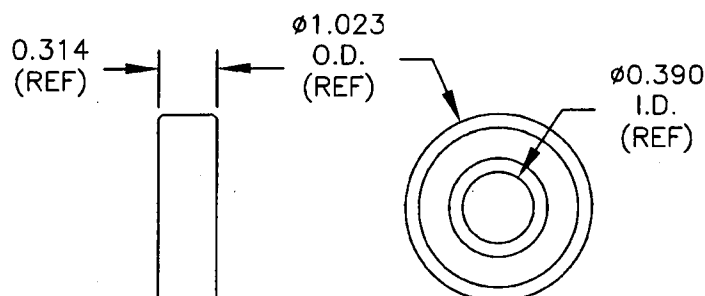
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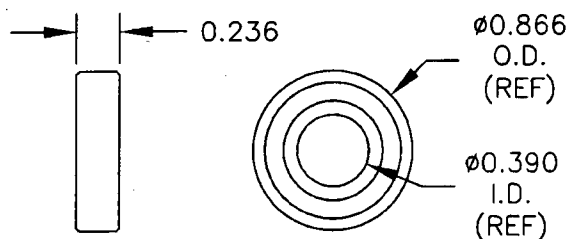
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| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. E SHEET 10 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:1 |

**D3121-17 WASHER (SCALE 2:1)**

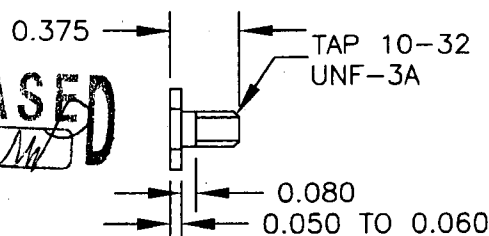
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

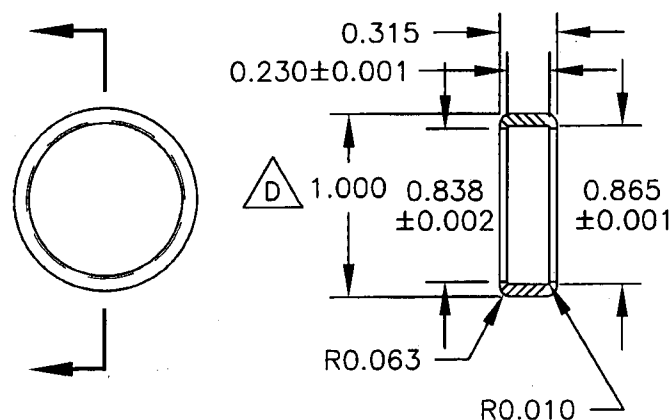
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

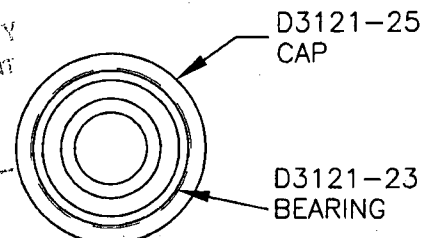
RELEASED
07.11.07**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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Inc.

www.gbs.ca

306 MAIN ST E, HAWKESBURY, ONTARIO K6A 1A8 (613) 632-9914

ORDER DATE: SEP 26, 2008

BST # R101979094

SOLD TO: DART AEROSPACE LTD.

1270 ABERDEEN STREET
SALE MADE BY: HAWKESBURY, ON.

CUSTOMER ORDER #: 00007216

PST LICENCE: 6122-5207

| PRODUCT | DESCRIPTION | QTY | UNIT | PRICE | EXTENSION |
|---------|--------------|-----|------|--------|-----------|
| 6000-22 | BALL BEARING | 40 | | 4.89 | 195.60 |
| 6000-22 | BALL BEARING | 60 | | 4.89 | 292.40 |
| 6000-22 | BALL BEARING | 25 | | 4.89 | 122.25 |
| 6000-22 | BALL BEARING | 225 | | 4.89 | 1,100.25 |
| | | | | G.S.T. | 83.57 |

PACKING SLIP NO: 6/0350-0

08/09/20

RECEIVED

THIS FORM MUST BE COMPUTER PRINTED TO BE VALID. E & O.E.

HT ETRE IMPRIME PAR ORDINATEUR POUR ETRE VALIDE. E & O.E.